

Work Order ID 77116

77116

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November-25-11 1:39:49 PM

Item ID: D3752-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame
 Start Date: 25/11/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3752	Rev C								
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut sheet to required size								
105		0.00							
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240°F</u>								
	Time IN: <u>4:00 pm</u> <u>11/12/07</u>								
	Time OUT: <u>2:00 am</u> <u>11/12/07</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Quality Control

付税. _____ *DL* _____
 11/12/07

$\times 3$ ² ₁ $\frac{11}{12}$ / 07

5/17/23 83 _____

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location <u>252A</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/22
(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

November-25-11 1:39:53 PM

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Work Order ID: 77116

77116

Parent Item: D3752-1

D3752-1

Parent Item Name: Seat Frame

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	288.0000	10.667	32.001			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

288

115261

288

32.001 sq ft

11/13/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77116
Description: Seat Frame		Part Number: D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: Dh **Date:** 11/12/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.041			ULTRA	
0.035	Min	0.056"			ULTRA	
0.040	Min	0.073			ULTRA	
0.075	Min	0.105"			ULTRA	
0.052	Min	0.090"			ULTRA	
0.021	Min	0.025"			Ultr DL-02	
0.036	Min	0.057"			Ultr DL-02	

Measured by: Dh **Date:** 11/12/07

Audited by: S **Date:** 11/12/22

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

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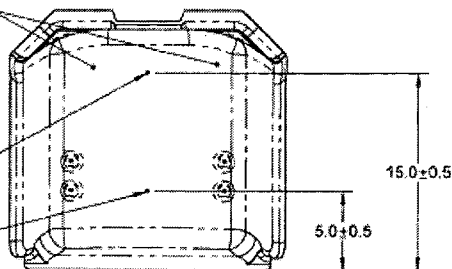
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ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE, 0.028 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE, 0.035 MIN THICKNESS AT THIS LOCATION



0.040 MIN THICKNESS ALONG TOP EDGE

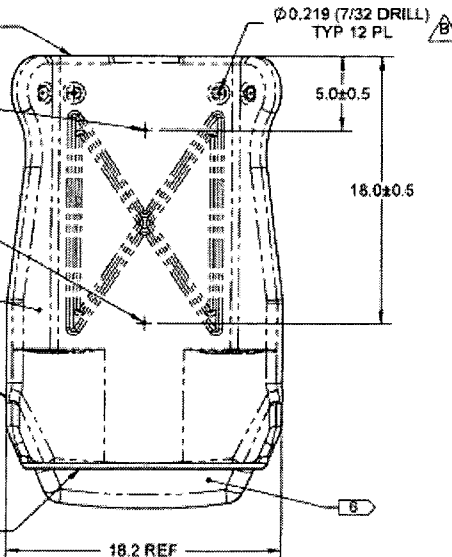
OPTIONAL TOOLING HOLE, 0.075 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE, 0.052 MIN THICKNESS AT THIS LOCATION

HEAVY HAIRCELL TEXTURE ON THIS SIDE

0.021 MIN THICKNESS IN THIS AREA (CORNER)

0.036 MIN THICKNESS ALONG BOTTOM EDGE

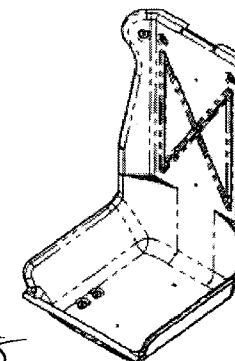


D3752-1 SEAT FRAME

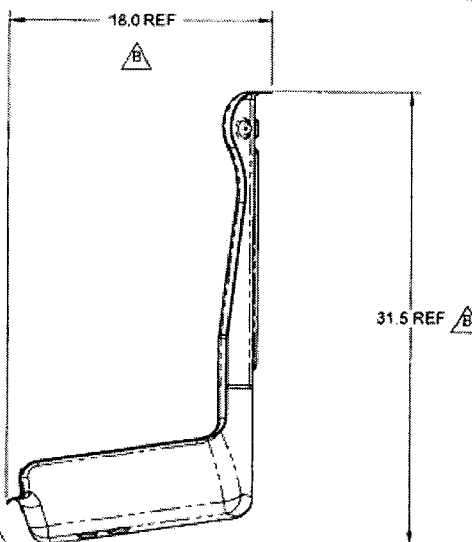
NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77116



M.C.J
11/11/25



RELEASED
08/11/05

C	REDUCE THICKNESS. 0.040 WAS 0.050 (ZIN C8-1), 0.075 WAS 0.100 (C8-1), 0.052 WAS 0.050 (B8-1), 0.021 WAS 0.030 (B8-1), 0.036 WAS 0.050 (A8-1), 0.028 WAS 0.035 (C8-1), 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1)	CP	08.10.05
B	FRONT PORTION NOW SHORTER (B5-1), 18.0 WAS 19.6 (C4-1), 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.10.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3752 TITLE SEAT FRAME SCALE NTS SHEET 1 OF 1 REV. C COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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